

Work Order ID 130180

February-26-15 9:20:18 AM

130180

Page 1

Item ID: D3186-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacepod Door, LH
 Start Date: 2/26/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3186	Rev E								

100
100 Small Fab 0.00
 Small Fab Memo 0.00
 Small Fab 1-Drill holes and cut out latch slots per dwg D3186 (D3186-3 detail)*** Trim and Fit***

ET 15-02-26 (12)

110
110 QC5- Inspect part completeness to step on W/O 0.00
 QC Memo 0.00
 Quality Control

(12) 15-03-02 DAS 9 988

120
120 Identify as per dwg & Stock Location CA2 0.00
 Packaging Memo 0.00
 Packaging

ET 15-02-26 (12)

130180

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 2/26/15 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 3/06/15 **Req'd Qty:** 2.00 ****2****

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MLJ 1503-02

AK 3-2

Picklist Print

February-26-15 9:20:18 AM

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Work Order ID: 130180

130180

Parent Item: D3186-3

D3186-3

Parent Item Name: Spacepod Door, LH

Start Date: 2/26/15

Required Date: 3/06/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-01-11 EC
IPP rev B rev D dwg 07.03.07 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3186-1M		Manufactured	No			100	Each	2.0000	1	2			
D3186-1M									**	<u>15-02-26</u>			
Spacepod Door LH													

Location

Loc Qty

Loc Code

CA

2

105010

1

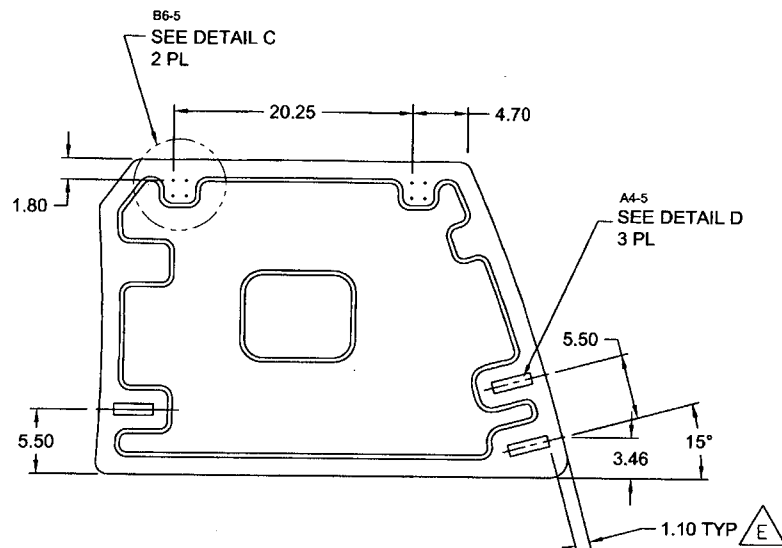
95065

1

x 1

x 1

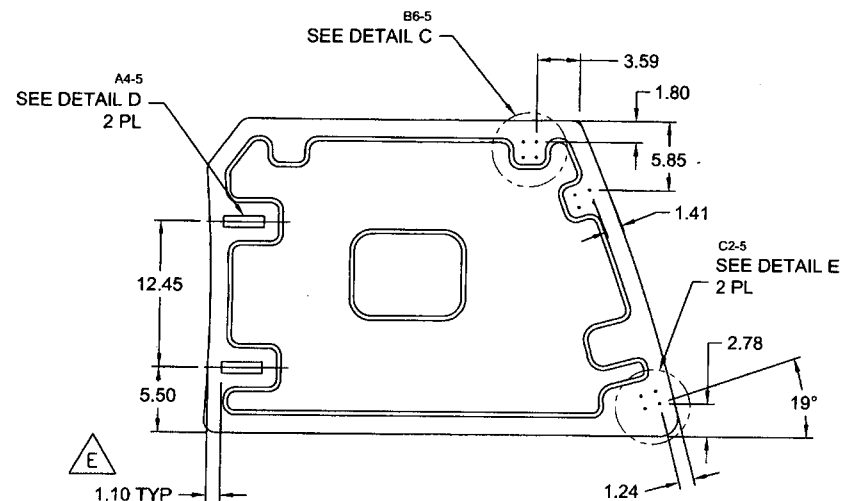
u/o 13080



D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

NOTES:

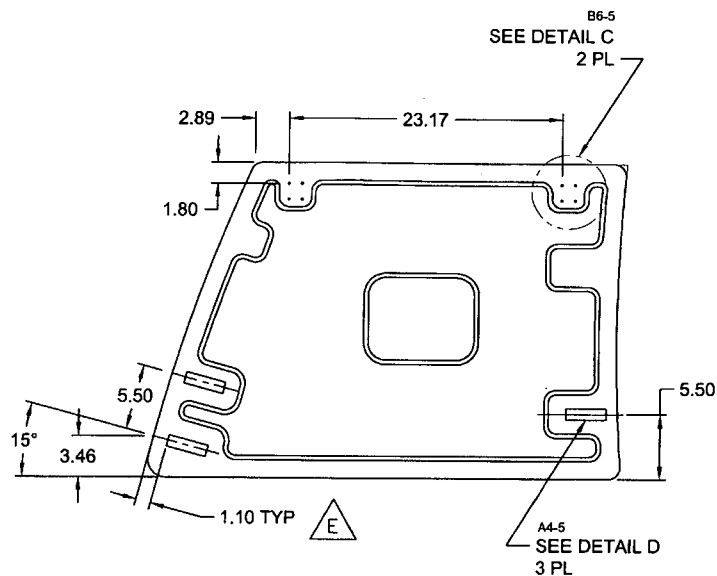
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



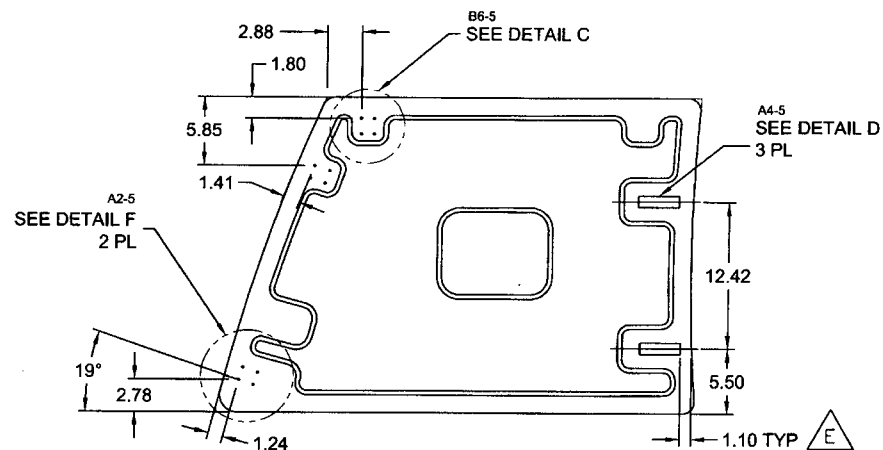
D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

RELEASED
2009-09-09

E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/2M/3/4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M



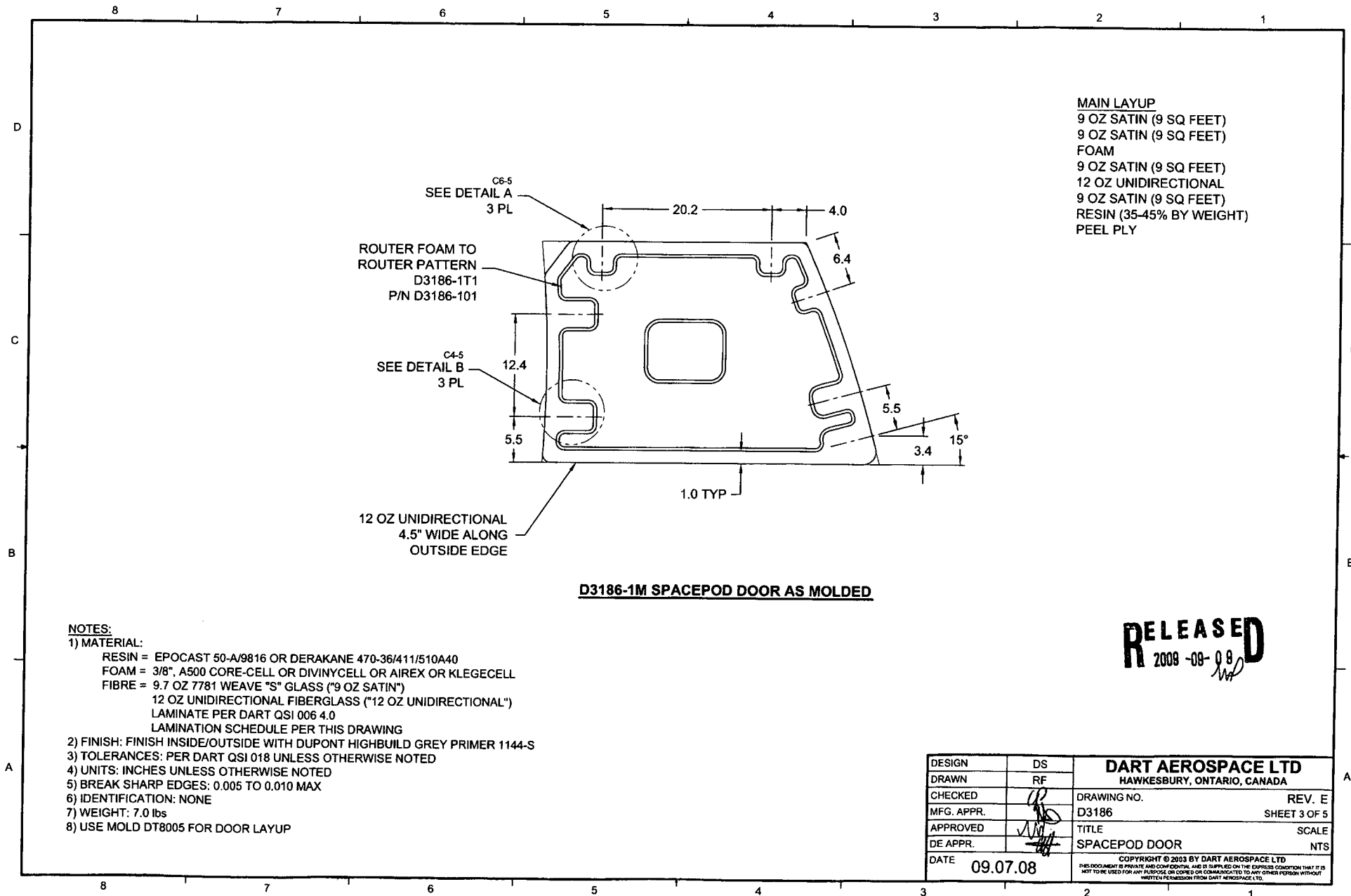
D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

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2009-09-09

NOTES:

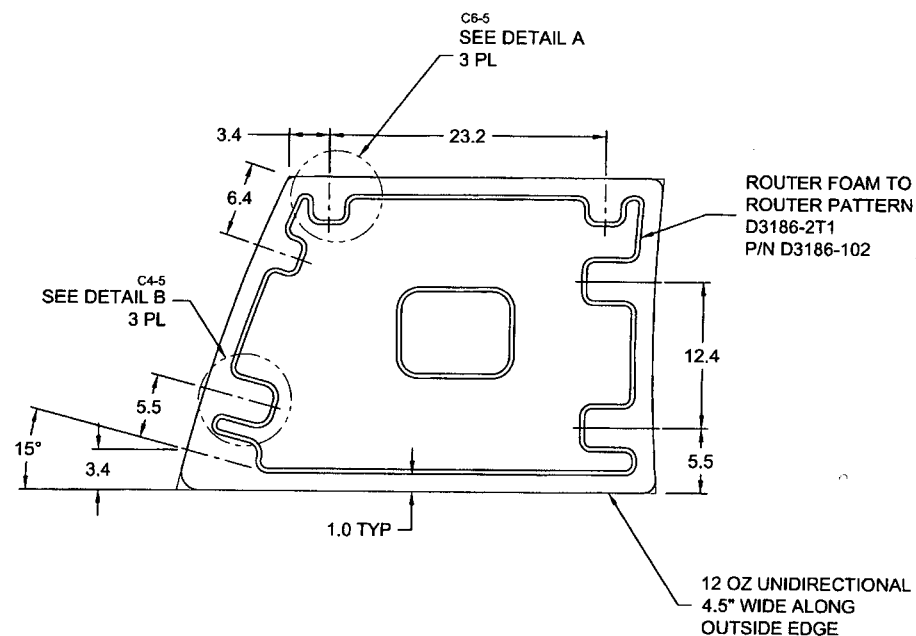
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 2 OF 5
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MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY



D3186-2M SPACEPOD DOOR AS MOLDED

NOTES:

1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 LAMINATE PER DART QSI 006 4.0
 LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

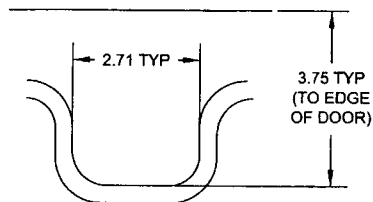
6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

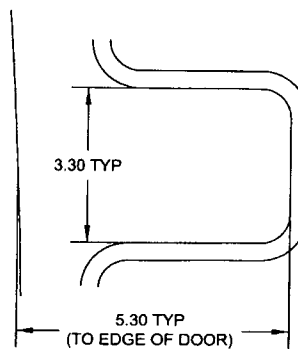
8) USE MOLD DT8006 FOR DOOR LAYUP

RELEASED
 2009-08-09

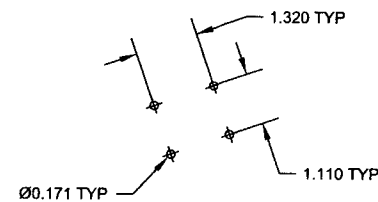
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MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 4 OF 5
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DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
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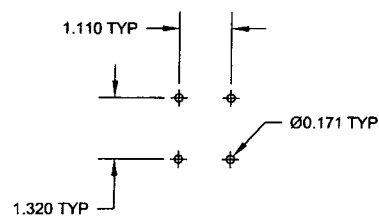
DETAIL A
SCALE 4X
D6-3
D4-4



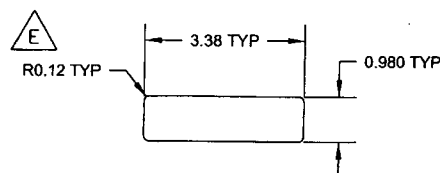
DETAIL B
SCALE 4X
C6-3
C6-4



DETAIL E
SCALE 4X
C1-1

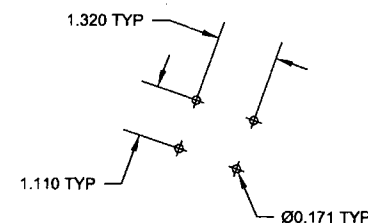


DETAIL C
SCALE 4X
D7-1
D3-1
D6-2
D3-2



NOTE: ENSURE THAT CUTOUT IS
PERPENDICULAR TO EDGE OF DOOR

DETAIL D
SCALE 4X
C5-1
D4-1
B6-2
C2-2



DETAIL F
SCALE 4X
C4-2

RELEASED
2009-09-09

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CHECKED	UF	DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 5 OF 5
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